

Date: Thursday, 23/10/2008 1:31:17 PM
User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SIDE DOOR |
| Job Number | : 42908 | | |
| Estimate Number | : 12295 | | |
| P.O. Number | : | Part Number | : D350589041 |
| This Issue | : 23/10/2008 S.O. No. : | Drawing Number | : D2991 REV.C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / | Drawing Revision | : C |
| Previous Run | : 42907 | Material | : |
| Written By | : | Due Date | : 20/11/2008 |
| Checked & Approved By | : <u>Julie Dawson 23.10.08</u> | Qty: | 1 Um: Each |
| Comment | : est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN 1096 DD verified by:EC est rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041 CHG002

509/01/08

| | | |
|-----|-----------------|------------------|
| 2.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|-----|-----------------|------------------|



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2449

Description: D2991-1 side door

Supplier: Delastek

batch:

Ship to delastek: Qty 1 D3721-1 Label

Qty 2 D2992-1 Doubler B 38737

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

208110124 (1)

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

2094/28 (1)

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: Ensure Material certification comply to Dwg D

2090107 / 2092/01/07 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---------------------------------|---|----------------|---------------------------|---------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08.12.19 | 10 | NOT ENOUGH THREADS ON SCREW FOR ATTACHING D3082-1 CLIP | UP 08.12.19 per QS1042 | SUBSTITUTE JD10 WASHER FOR AN960JD10L BIN 105793 (3) | BR 08-12-23 | S 09/01/07 | UP 08.12.19 per QS1042 | S 09/01/07 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 1:31:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 42908

Part Number: D350589041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|-----------|
| 5.0 | D29911 | Side Door |
|-----|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Side Door

| | | |
|-----|-----------|---------------|
| 6.0 | D24641700 | Neoprene Seal |
|-----|-----------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 1 | D2464-1700 | Foam seal |

Batch 39669

SS 08/12/15 (X)

| | | |
|-----|-------|------------------|
| 7.0 | D2585 | Mounting Channel |
|-----|-------|------------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 3 | D2585 | Latch clamp |

Batch 43922

SS 08/12/15 (X)

| | | |
|-----|-------|------------|
| 8.0 | D2586 | Door Latch |
|-----|-------|------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 3 | D2586 | Door latch |

Batch 39783

SS 08/12/15 (X)

| | | |
|-----|-------|---------------------------|
| 9.0 | D2621 | Latch Plate, 350 Spacepod |
|-----|-------|---------------------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 3 | D2621 | latch plate |

Batch 33894

SS 08/12/15 (X)

| | | |
|------|----------|------------|
| 10.0 | D3085041 | prop ass'y |
|------|----------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 1 | D3085-041 | prop ass'y |

Batch 38320

BR 08-12-23 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 1:31:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 42908

Part Number: D350589041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----------|--------|
| 11.0 | AN960JD10 | Washer |
|------|-----------|--------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 3 | AN960JD10 | Washer |

Batch

M109061

SS 08/12/15 (XL)

| | | |
|------|-----------|-----|
| 12.0 | MS21042L3 | Nut |
|------|-----------|-----|



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part number | Description |
|-----|-------------|-------------|
| 9 | MS21042L3 | Nut |

Batch

M109031

SS 08/12/15 (XL)

| | | |
|------|------------|-------|
| 13.0 | MS27039115 | Screw |
|------|------------|-------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part number | Description |
|-----|--------------|-------------|
| 3 | MS27039-1-15 | Screw |

Batch

M109321

SS 08/12/15 (XL)

| | | |
|------|-------------|-------------------------------|
| 14.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589

SS 08-12-23

| | | |
|------|-----|------------------------------|
| 15.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SS 08/12/15 (XL)

| | | |
|------|-------------|-----------------------|
| 16.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick list:

| | | |
|------|-------|---------------|
| 17.0 | D2237 | Striker Plate |
|------|-------|---------------|



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part number | Description |
|-----|-------------|---------------|
| 3 | D2237 | Striker Plate |

Batch

41163

SS 08/12/15 (XL)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 1:31:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 42908

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch
1 D2589 keys, key chain 39814

SS 08/12/15 (X)

19.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description Batch
6 AN3-4A Bolt M103641

SS 08/12/15 (X)

20.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description Batch
6 MS20470AD4-5 Rivet M106918

Batch not in comp

SS 08/12/15 (X)

21.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

M109631 x2 M108816 x1

SS 08/12/15 (X)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Rev D 9/1/08

SD

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/08 MF 09-01-08

Job Completion



QC #4 inspection 09/01/08

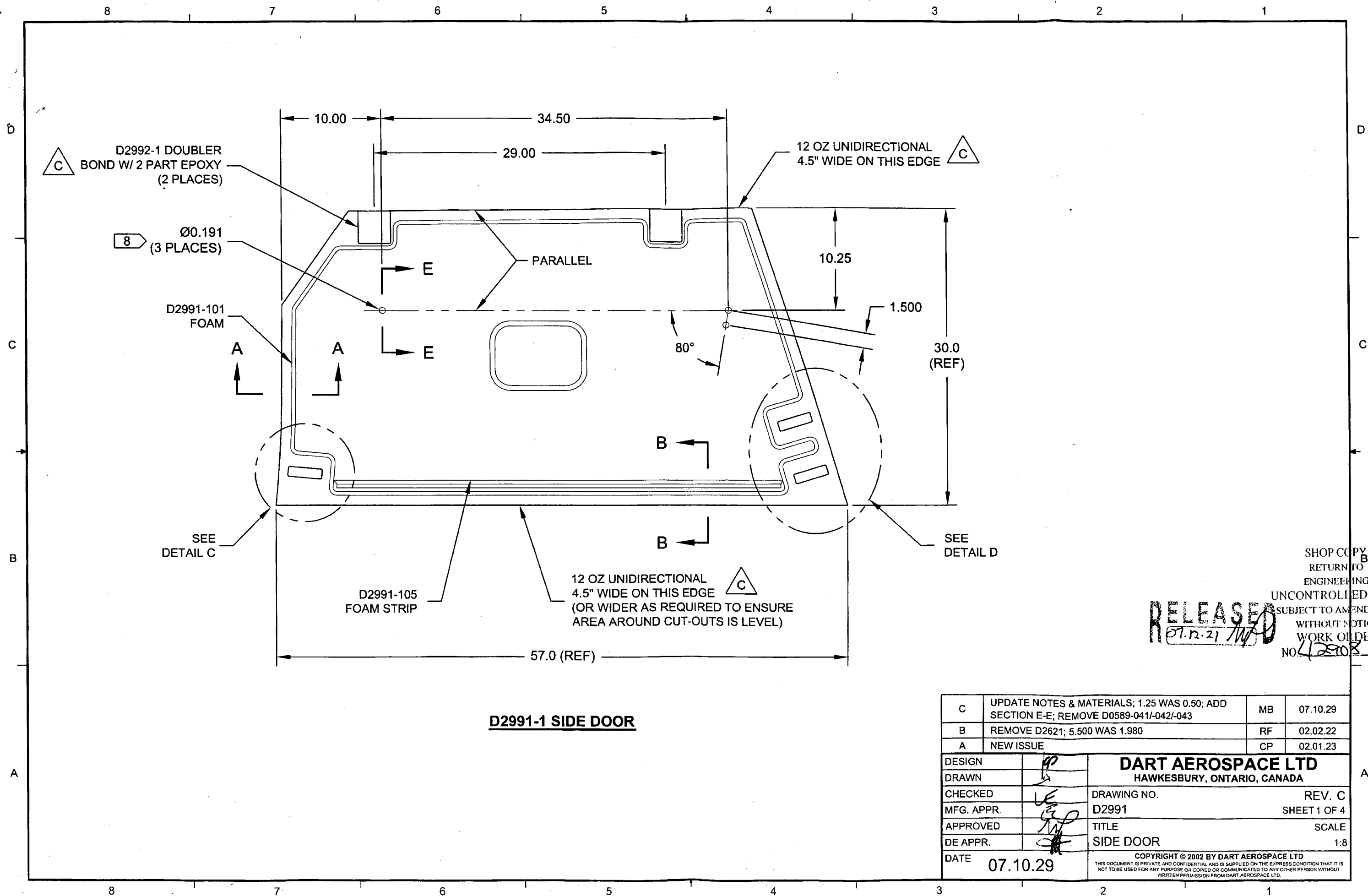
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

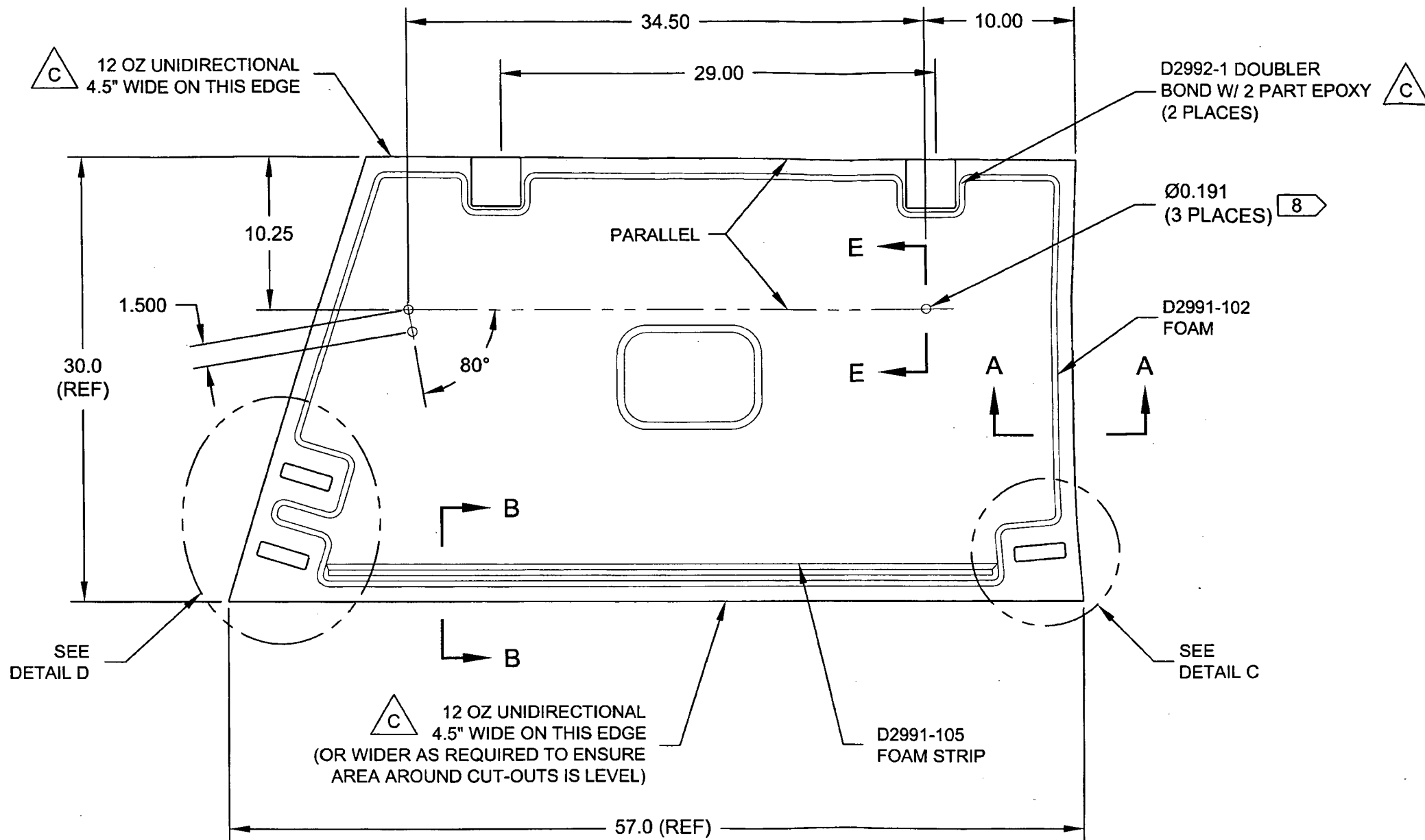
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



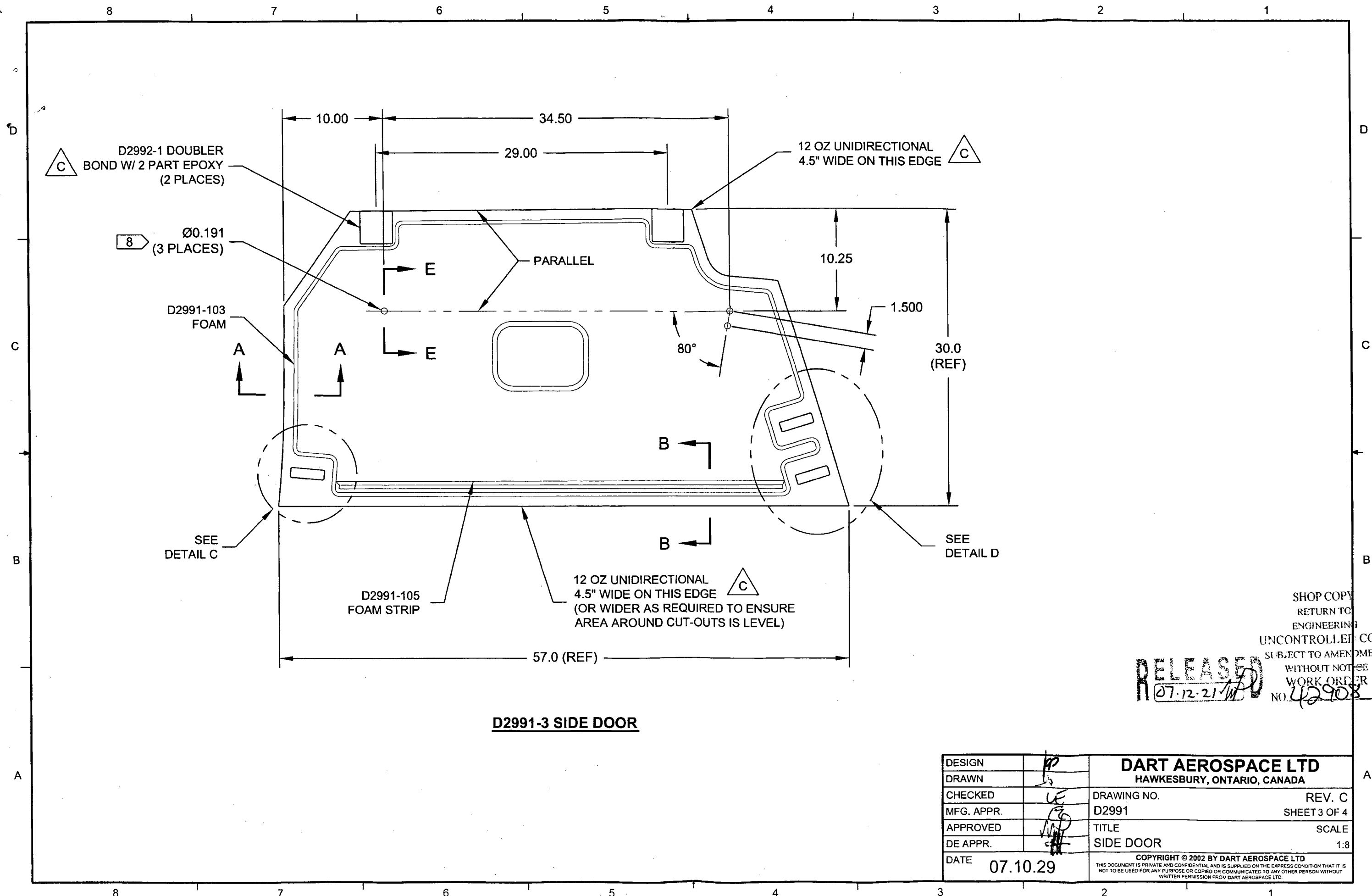


D2991-2 SIDE DOOR

RELEASED
07.12.21

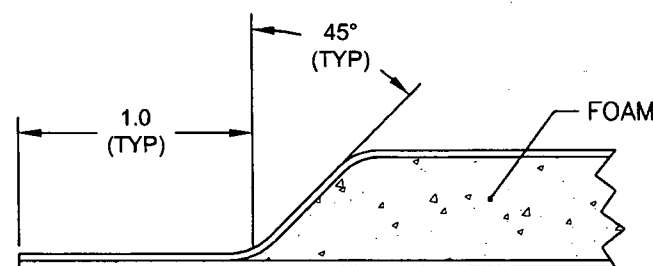
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42908

| | | | |
|--|----------|--|--------------|
| DESIGN | BP | DART AEROSPACE LTD | |
| DRAWN | LS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | UC | DRAWING NO. | REV. C |
| MFG. APPR. | GP | D2991 | SHEET 2 OF 4 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | MP | SIDE DOOR | 1: |
| DATE | 07.10.29 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |



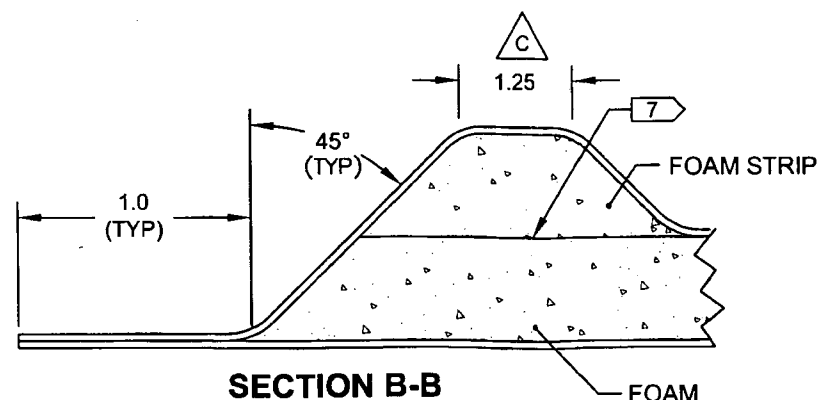
RELEASED
 07.12.21
 NO. 42908

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER



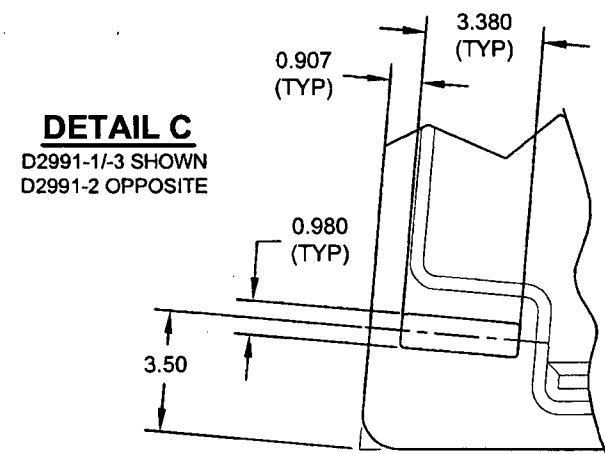
SECTION A-A

NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



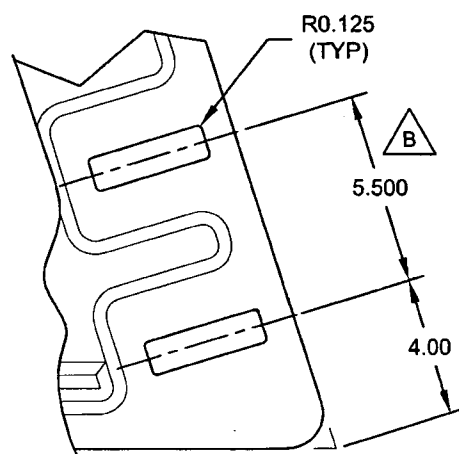
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



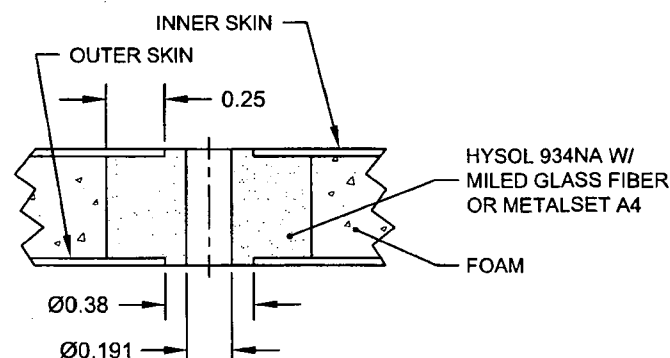
DETAIL C

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/-3 SHOWN
D2991-2 OPPOSITE









SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/-2/-3

- LAYUP PER QSI 006 AND AS FOLLOWS
- MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- BOND FOAM CORE USING POLYBOND B46F
- DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- WEIGHT: 9 lbs (TYP)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42908

| | | | |
|--|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. C |
| MFG. APPR. |  | D2991 | SHEET 4 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | SIDE DOOR | 1: |
| DATE | 07.10.29 | COPYRIGHT © 2002 BY DART AEROSPACE LTD | |
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Date: Friday, 14/11/2008 2:10:20 PM
User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SIDE DOOR |
| Job Number | : 42908 | | |
| Estimate Number | : 12295 | | |
| P.O. Number | : | Part Number | : D350589041 |
| This Issue | : 14/11/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2991 REV.C |
| First Issue | : 23/10/2008 | Project Number | : N/A |
| Previous Run | : 42907 | Drawing Revision | : C |
| | Type : PURCHASED PARTS | Material | : |
| Written By | : | Due Date | : 20/11/2008 |
| Checked & Approved By | : | Qty: | 1 |
| Comment | Um: Each | | |
| | : est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN 1096 DD verified by:EC est rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD | | |

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 DC

DOCUMENT CONTROL



520 08.11.07



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041 CHG002

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Description:D2991-1 side door

Supplier:Delastek

batch: _____

Ship to delastek: Qty 1 D3721-1 Label _____

Qty 2 D2992-1 Doubler _____

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

Job Completion





DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

| | |
|------------|-------|
| Invoice # | 13039 |
| Customer # | DART |

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

| Ship via | | F.O.B. | | Terms | | Salesperson | |
|--------------|------------|-----------------|----------------|---|------------|--------------------------|--|
| PURO COLLECT | | Point de départ | | Net30 days | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | | Your PO # | GST/PST # | |
| 27/11/2008 | 24/10/2008 | 5920 | Chantal Lavoie | | PO00007449 | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | ✓ 1 | DKC134-0050 | Side Door N° D2991-1 B42908 Dwg.: D2991 Rév.: C Job: 43444 U de M : Each | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Mardi, 2008-10-28 10:07:33
Utilisateur: Marc Dubé

Feuille de Procédé

| | | | | |
|------------------------|-------------------------------|-----------------|------------------------|-------|
| Client | : DART Dart Aerospace Ltd. | Nom Dessin | : SIDE DOOR N° D2991-1 | 3 |
| Numéro Job | : 43444 | Numéro Article | : DKC134-0050 | |
| Numéro Soumission | : 2622 | Numéro Dessin | : D2991 | |
| Numéro B.A. | : | Projet Numéro | : DKC134 | |
| Cette fois | : 2008-10-28 | Révision dessin | : C | |
| Prsht Rev. | : NC | Matériel | : Composites | |
| Prem. fois | : - - | Date Dûe | : 2008-11-04 | |
| Job précédente | : 43443 | Qté: | 1 Udm: | UNITE |
| Écrit par | : | | | |
| Vérifié & Approuvé par | : | | | |
| Commentaires | : N° de pièce Client: D2991-1 | | | |



Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0

NOTE

NOTE GÉNÉRALE DE FABRICATION



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
Information générale de fabrication

Liste des instructions de fabrication et Instruction générale de fabrication nécessaires à la fabrication de la pièce:

IG 0008 Application de primer Dupont.
IG 0009 Traitement des moules agent démoulant (Freekote)
IG 0012 Montage de Vacuum Bagging et cuisson
IG 0018 Démouler une pièces de fibre de verre fabriquée en Wet Layup
IG 0019 Application du Gelcoat

2.0

OUTILLAGE

OUTILLAGE NÉCESSAIRE À LA FABRICATION



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
Outillage nécessaire pour la fabrication

DKO-0094

3.0

AAC0582

Freekote 700NC N° 38425

Commentair Qty.: 0.025 GALLON(s)/Unit Total : 0.025 GALLON(s)
Freekote 700NC N° 38425

4.0

PRÉP. MATÉRIEL

PRÉPARATION DU MATÉRIEL



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
Sortir le matériel

Faire la préparation du matériel pour la production

Date: Mardi, 2008-10-28 10:07:33

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43444

Numéro Article: DKC134-0050

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: _____ Sceau: _____

5.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
Préparation du moule

Faire la préparation du moule N° DKO-0094 à l'aide de Frekote 700NC et laisser sécher pendant 3 heures selon le QSI-006 et l'instruction générale de fabrication N° IG 0009.

Date: 17-11-08 Sceau:

6.0

AAC0273

Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005

7.0 AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0250 PINTE(s)/Unit Total : 0.0250 PINTE(s)
Catalyst N° DDM-9

8.0 AAC0198

UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
UN2055 styrene monomere ST

9.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 5% de UN2055 styrene monomere ST

Date: 18-11-08 Sceau: Temps Début: 9:15 Temps Fin: 9:30

10.0

GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
APPLICATION DE GEL COAT

Faire l'application du Blanc N° Gel 944W005 sur le moule N° DKO-0094 selon l'instruction Générale de fabrication N°IG 0019

Date: 18-11-08 Sceau:

Date: Mardi, 2008-10-28 10:07:33
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43444

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|---------------------------------|
| 11.0 | AC0409 | Tissu à délaminer Release ply B |
|------|--------|---------------------------------|

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Tissu à délaminer Release ply B

| | | |
|------|--------|------------------------|
| 12.0 | AC0407 | Wrightlon 5200 Bleu P3 |
|------|--------|------------------------|

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Wrightlon 5200 Bleu P3

| | | |
|------|--------|-------------------------------------|
| 13.0 | AC0408 | Feutre de drainage N° Airweave N 10 |
|------|--------|-------------------------------------|

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)
Feutre de drainage N° Airweave N 10

| | | |
|------|--------|----------------------------------|
| 14.0 | AC0752 | Stretchlon 200 poche à vide Vert |
|------|--------|----------------------------------|

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)
Stretchlon 200 poche à vide Vert

| | | |
|------|---------|--|
| 15.0 | AAC0276 | Fiberglass 9oz Type "S" N° FG778138-125Y |
|------|---------|--|

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)
Fiberglass 9oz Type "S" N° FG778138-125Y

| | | |
|------|---------|---------------------------------|
| 16.0 | AAC0443 | Fiberglass 12 oz Unidirectional |
|------|---------|---------------------------------|

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)
Fiberglass 12 oz Unidirectional

| | | |
|------|--------|-----------------------------------|
| 17.0 | AC0098 | Ruban à gommer jaune #: T/AT-200Y |
|------|--------|-----------------------------------|

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

| | | |
|------|---------------|------------------------------|
| 18.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Strechlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 17-11-08 Sceau:



Date: Mardi, 2008-10-28 10:07:33
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43444

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|--|
| 19.0 | AAC0274 | Derakane 411-350 Promoté N° RV411B3020 |
|------|---------|--|

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)
Derakane 411-350 Promoté N° RV411B3020

| | | |
|------|---------|-------------------|
| 20.0 | AAC0275 | Catalyst N° DDM-9 |
|------|---------|-------------------|

Commentair Qty.: 0.0060 UNITE(s)/Unit Total : 0.0060 UNITE(s)
Catalyst N° DDM-9

| | | |
|------|---------------|------------------------------|
| 21.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 18-11-08 Heure Début: 1:00 Heure Fin: 1:05 Sceau:

| | | |
|------|-----------|---------------------|
| 22.0 | LAMINAGE. | LAMINAGE PIÈCE DART |
|------|-----------|---------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0094 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 18-11-08 Heure Début: 1:05 Heure Fin: 1:25 Sceau:

| | | |
|------|----------------|-----------------------|
| 23.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 18-11-08 Sceau:

Curing début: 1:05 Curing Fin: 9:00

Date: Mardi, 2008-10-28 10:07:33

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43444

Numéro Article: DKC134-0050

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|---------------|
| 24.0 | AAC0452 | Polybond B46F |
|------|---------|---------------|

Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.143 KIT(s)
Polybond B46F

| | | |
|------|-------------|--|
| 25.0 | DKC134-0062 | Foam Core N° D2991-101 (Porte D2991-1) |
|------|-------------|--|

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Foam Core N° D2991-101 (Porte D2991-1)

| | | |
|------|--------------|--------------------------|
| 26.0 | ASSEMBLAGE 3 | ASSEMBLAGE GÉNÉRALE DART |
|------|--------------|--------------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0062 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 19-11-08 Heure Début: 11:25 Heure Fin: 11:45 Sceau:

| | | |
|------|----------------|-----------------------|
| 27.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 19-11-08 Sceau:

Curing Début: 11:25 Curing Fin: 1:00

| | | |
|------|---------|--|
| 28.0 | AAC0274 | Derakane 411-350 Promoté N° RV411B3020 |
|------|---------|--|

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)
Derakane 411-350 Promoté N° RV411B3020

| | | |
|------|---------|-------------------|
| 29.0 | AAC0275 | Catalyst N° DDM-9 |
|------|---------|-------------------|

Commentair Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s)
Catalyst N° DDM-9

Date: Mardi, 2008-10-28 10:07:33
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43444

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------------|------------------------------|
| 30.0 | PRÉPARATION 3 | PRÉPARATION DU MATÉRIEL DART |
|------|---------------|------------------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 20-11-08 Heure Début: 1:50 Heure Fin: 1:55 Sceau:

| | | |
|------|-----------|---------------------|
| 31.0 | LAMINAGE. | LAMINAGE PIÈCE DART |
|------|-----------|---------------------|



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 20-11-08 Heure Début: 1:55 Heure Fin: 2:35 Sceau:

| | | |
|------|----------------|-----------------------|
| 32.0 | POCHE À VIDE 1 | FAIRE LA POCHE À VIDE |
|------|----------------|-----------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 20-11-08 Heure Début: 2:35 Heure Fin: 2:45 Sceau:

Curing Début: 1:55 Curing Fin: 8:00

Date: Mardi, 2008-10-28 10:07:33

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43444

Numéro Article: DKC134-0050

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 21-11-08 Sceau:



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE COMPOSITES DART

À l'aide du gabarit N° DKO-0118 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 21-11-08 Sceau:



35.0

AAC0433

Hysol 934NA part A&B (quart kit)

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)
Hysol 934NA part A&B (quart kit)

36.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s)
Fibre de verre Miapoxy 66

37.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

À l'aide du Gabarit N° DKO-0118 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préallablement fait dans le foam Core.

Laisser sécher.

Date: Mardi, 2008-10-28 10:07:33
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43444

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0050

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 24-11-08

Sceau:



38.0

TRIMAGE

TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE DE FINITION

À l'aide du gabarit N° DK6 - 0118 Repercer les 3 trous de 1/4" Dia.

Date: 26-11-08

Sceau:



39.0

AAC0433

Hysol 934NA part A&B (quart kit)

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)
Hysol 934NA part A&B (quart kit)

40.0

AAC0697

N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)
N° D2992-1, Doubler

41.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIECES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 25-11-08

Sceau:



42.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)
Dupont Primer N° 7704S

43.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)
Dupont Activator - Reducer Chromabase N° 7775S

44.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
APPLICATION DE PRIMER

Appliquer le primer selon I.G. 0008

Date: 25/11/08

Sceau:



Date: 27/11/08

Sceau:



finition

Date: Mardi, 2008-10-28 10:07:33

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43444

Numéro Article: DKC134-0050

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: _____ Sceau: _____

Date: _____ Sceau: _____

45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2991

Date: 27/10/07 Heure Début: 2h00 Heure Fin: 2h15 Sceau: _____



46.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1 Date: 27-11-08 Sceau: _____



Quantité: _____ Date: _____ Sceau: _____

Date: Thursday, 18/12/2008 12:52:00 PM
 User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SLIDING BLOCK |
| Job Number | : 44179 | | |
| Estimate Number | : 13536 | | |
| P.O. Number | : | Part Number | : D38091 |
| This Issue | : 18/12/2008 S.O. No. : | Drawing Number | : D3809 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 18/12/2008 Type : MACHINED PARTS | Drawing Revision | : A |
| Previous Run | : 41118 | Material | : |
| Written By | : | Due Date | : 05/01/2009 Qty: 16 Um: Each |
| Checked & Approved By | : <u>JLD 08.12.19</u> | | |
| Comment | : Est Rev:A nEW iSSUE 08-08-01 JLM | Verified By:DD | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | MDELRLNB0250X01000 | Delrin Bar 0.25" x 1.0" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.1575 f(s)/Unit Total: 2.5200 f(s)

Delrin Bar 0.25" x 1.0"

BATCH: M103039 - *not in computer*

JL 08/12/23

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut Blanks 1.850" long

JL 08/12/23

| | |
|-----|-------|
| 3.0 | HAAS1 |
|-----|-------|



Comment: HAAS CNC VERTICAL MAC

1- Mill as per Folio FA770 Rev

2-Deburr per dwg D3809

106805
43770

| | |
|-----|-----|
| 4.0 | QC2 |
|-----|-----|



Comment: INSPECT PARTS AS THEY COM

JL 08/12/27

| | |
|-----|-----|
| 5.0 | QC8 |
|-----|-----|



Comment: SECOND CHECK

JL 08/12/28 *(Signature)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 18/12/2008 12:52:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING BLOCK

Job Number: 44179

Part Number: D38091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57119

JS 08/12/30 RTG

Job Completion



QC21 final inspection w/o release 1209/01/06 (12)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

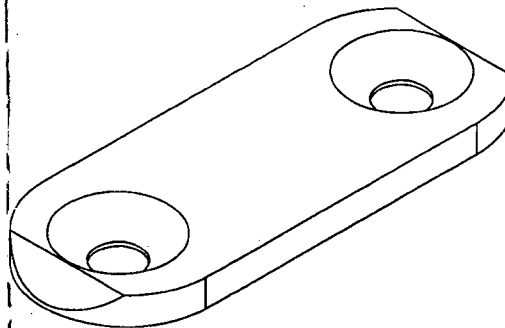
NOTE: Date & initial all entries

8

7

2

1



D

D

C

C

B

B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
08-07-27/1779

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACE BAR (REF. DART SPEC. M-DELF)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.004 lbs

| | | |
|--|--------------|----------|
| | RF | 08.07.24 |
| DESCRIPTION | BY | DATE |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWING NO. | REV. A | |
| D3809 | SHEET 1 OF 1 | |
| TITLE | SCALE | |
| SLIDING BLOCK | NTS | |
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| DART AEROSPACE LTD | Work Order: | 44179 |
| Description: Sliding block | Part Number: | D3809-1 |
| Inspection Dwg: D3809 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

| | | | | | | | |
|-------------------|--|-------------|--|---------------------|--|-----|--|
| Measured by: J.L. | | Audited by: | | Prototype Approval: | | N/A | |
| Date: 08/12/27 | | Date: | | Date: | | N/A | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |